

Work Order ID 142600

Thursday, March 10, 2016 2:19:01 PM

142600

Page 1

Item ID: D4635-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Ceiling Panel Assembly, RH
 Start Date: 3/14/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/30/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: chf Date: 16-3-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	F								
100		0.00							DAS 07 9-89
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								16/03/29
110		0.00							DAS 07 9-89
110									
Small Fab	Memo	0.02							
Small Fab	1- Assemble as per Dwg D4635-044								16/03/30
	2-Install speaker								
	3- Install Air valve								
	4-Install Wiring Harness								
	5-Install wiring harness								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

142600

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/14/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/30/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

① 16.0330

DAS

9

9-89

130

Identify as per dwg & Stock Location

0.00

130

Packaging

Memo

0.00

Packaging

1x

DAS
28
9-89

MAR 31 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

mcs

MAR 31 2016

WVF
16-3-3

DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

Thursday, March 10, 2016 2:19:00 PM

Page 1

Work Order ID: 142600

142600

Parent Item: D4635-044

D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 3/14/2016

Required Date: 3/30/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc Release DL
Update 13/07/09 DL verf:DD
13/12/09 DL
Ipp Rev. E Dwg Update 14/01/09 DL
Dwg. Update 15/01/27 DL

IPP Rev B
IPP Rev. C Dwg.
IPP Rev D Dwg Update
IPP Rev. F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-144		Manufactured	No			100	Each	0.0000	1	1			DAS 07 9-89
✓ *D4635-144*					W/O # 142610				**	①			
Aft Ceiling Replacement Panel Assembly, RH													
D4646-1		Manufactured	No			100	Each	135.0000	1	1			DAS 07 9-89
✓ *D4646-1*									**				
Plenum Cap Assembly													
PTC - last Page													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF009		135				①			
				124234	63.	81							
				125003		54							
D4652-5		Manufactured	No			100	Each	0.0000	1	1			DAS 07 9-89
✓ *D4652-5*					112003				**	①			
Air Valve, 1.25 Id Disk Type													
D4655-1		Manufactured	No			100	Each	44.0000	1	1			DAS 07 9-89
✓ *D4655-1*									**				
Speaker													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MF002	44	
111827	15	
112009	1	
117634	24	
92333	2	
93061	2	

16/03/21

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Page 2

Work Order ID: 142600

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Parent Item: D4635-044

D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 3/14/2016

Required Date: 3/30/2016

Start Qty: 1.00

Required Qty: 1.00

D4708-9

Manufactured No

100

Each

26.0000

1

1

DAS
07
9-89

D4708-9

Lanyard

**

Location

Loc Qty

Loc Code

MF004

26

112122

26

100

Each

20.0000

1

DAS
07
9-89

D4728-046

Manufactured No

D4728-046

RH Cabin Speaker #3

**

Location

Loc Qty

Loc Code

MF002

5

117928

5

MF009

15

124239

15

100

Each

22.0000

1

DAS
07
9-89

D4743-1

Manufactured No

D4743-1

Speaker Grill

**

Location

Loc Qty

Loc Code

MF005

22

129268

22

100

Each

163.0000

4

DAS
07
9-89

MS21044-N08

Purchased No

MS21044-N08

Nut

**

Location

Loc Qty

Loc Code

ST302

160

m131452

160

ST303

3

m127813

2

m130297

1

Thursday, March 10, 2016 2:19:00 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Thursday, March 10, 2016 2:19:00 PM

Page 3

Work Order ID: 142600

Parent Item: D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

142600

D4635-044

Start Date: 3/14/2016

Required Date: 3/30/2016

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG8

Purchased

No

100

Each

76.0000

3

3

DAS

07

9-89

MS21919-WDG8

Clamp

**

Location

Loc Qty

Loc Code

ST293

76

m128057

76

100

Each

527.0000

4

4

DAS

07

9-89

MS24693-BB51

Purchased

No

MS24693-BB51

Screw

**

Location

Loc Qty

Loc Code

ST288

527

m128057

527

100

Each

2,171.000

4

4

DAS

07

9-89

NAS1149DN832J

Purchased

No

NAS1149DN832J

Washer

**

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST260a

1500

M134180

1500

ST263

587

M131697

587

Thursday, March 10, 2016 2:19:00 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____

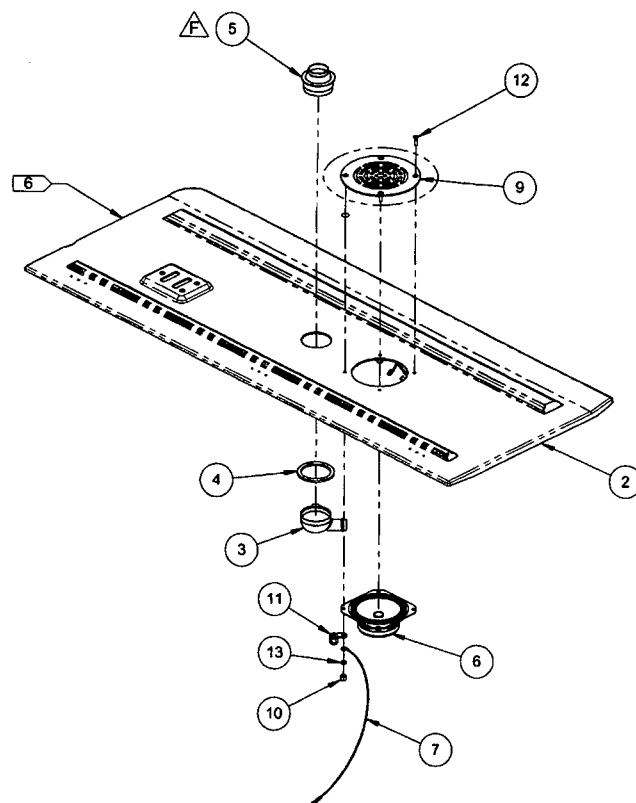


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					



D4635-044 RH, AFT CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 5.0 lbs
- 8) INSTALL D4728-046 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

ITEM	QTY -044	P/N	DESCRIPTION
1	X	D4635-044	RH, AFT CEILING PANEL ASSY
2	1	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
5	1	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-046	RH SPEAKER #3 HARNESS ASSY
9	1	D4743-1	SPEAKER GRILL
10	4	MS21044-N08	NUT, SELF-LOCKING
11	3	MS21919WDG8	CLAMP
12	4	MS24693-BB51	SCREW, CSK 100*
13	4	NAS1149DN832J	WASHER

#142600

RELEASED

2015 JAN 26 up

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 7 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

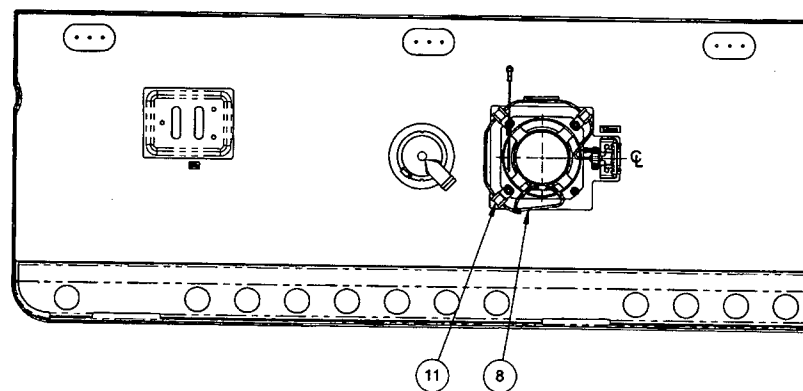
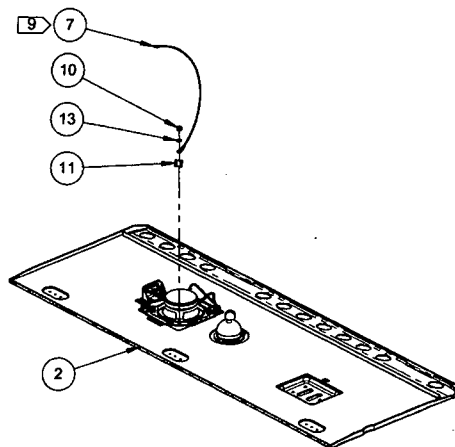


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OTHER : ☐					



D4635-044 RH, AFT CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED
2015 JAN 26 *q*

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 8 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DRAWING NO. D4635	TITLE OUTBOARD CEILING PANELS	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D4635-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN RF	CHECKED VS	MFG. APPR.	TBD	APPROVED	TBD	DE APPR.	
DATE 15.06.03	DATE 15.06.03	DATE 15.06.03		DATE 15.06.03		DATE	

PURPOSE:

IT IS ACCEPTABLE TO USE D4652-1 AIR VALVE IN LIEU OF D4652-5 AIR VALVE UNTIL STOCK DEPLETED.
A COMPLETE D139-816-011 CEILING PANEL KIT MUST USE THE SAME P/N AIR VALVE IN ALL LOCATIONS.